

SPLIT  
21946  
D205-711-013  
1

DART AEROSPACE LTD		Work Order:	21946
Description: Vertical Reference Door Installation, 205		Part Number:	D205-711-013
Dwg:		Qty:	1
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																
1	DC	Issue Traveler	HA	04.11.23	4																
2	DC	Photocopy bluefiles and create labels per PPP D205-711-013 CHG001	UK HA	okay-step 5.																	
3	KP Eagle	<b>Pick: Packing Kit</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D412-711-041</td><td>Vertical Reference Door</td><td>B-1526544</td></tr><tr><td>1</td><td>D205-711-113</td><td>Wiring Harness, 205</td><td>B-21902</td></tr><tr><td>1</td><td>EA20469-15-205</td><td>Instrument Panel, 205</td><td>M19150</td></tr></table> <b>Attach serviceable tags</b>	Qty	Part Number	Description	Batch	1	D412-711-041	Vertical Reference Door	B-1526544	1	D205-711-113	Wiring Harness, 205	B-21902	1	EA20469-15-205	Instrument Panel, 205	M19150			
Qty	Part Number	Description	Batch																		
1	D412-711-041	Vertical Reference Door	B-1526544																		
1	D205-711-113	Wiring Harness, 205	B-21902																		
1	EA20469-15-205	Instrument Panel, 205	M19150																		
4	QC4 Eagle	Inspect Kit 100% for Completeness on the W/O	HA	06/17/18	1																
5	PK Eagle	Identify and pack for shipping as per PPP D205-711-013 Draft	HA	06/17/18	1																
6	AC	Cost / part: _____	HA	06-07-15	1																
7	DC	Close W/O Inspect Level 21	HA	06-07-17																	

Rev	Date	Change	Revised By	Approved
A	04.11.09	New issue	KJ/JLM	

26 PG

Issue for to Eagle Corpers  
for 1 x D205-711-013 DO 200-7213

Ensure AOC + Cert. of Conformity Attached

RELEASED  
04-12-01  
04-11-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: PD Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 22, 2004  
03:12 pm

Work Order No : 0021946  
Project Name : D205-711-013  
Project For : WK  
Work Order Type : Main  
Main WO Number :  
House Part Number : \*D205-711-013  
Description : Vertical Reference Door  
Manufactured : Yes  
Amount Req'd : 4  
Amount Done : 0  
Start Date : 11-22-04  
Est Finish Date : 12-21-04  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



Dart Aerospace Ltd.

Date:  
User:Wednesday, 4/5/2006 3:23:58 PM  
Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : VERTICAL REFERENCE DOOR ASSEMBLY  
 Job Number : 26544  
 Estimate Number : 10902  
 P.O. Number : N/A Part Number : D412711041  
 This Issue : 4/5/2006 S.O. No. : N/A Drawing Number : N/A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : N/A  
 Previous Run : 26543 Material : N/A  
 Written By : SEE COMMENT REPLY Due Date : 4/28/2006 Qty: 1 Unit Each  
 Checked & Approved By : 06.04.06  
 Comment : Est Rev. A 04.08.18 New Issue KJDS

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 977 to Eagle Copters

"Assembly of D412-711-041 Door Assembly in accordance with D412-711-041"

Send a copy of this IPP

06.04.10 (1)

2.0

D412711041

Vertical Ref. Door Assy



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Vertical Ref. Door Assy

3.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

## EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door 42456

Attach serviceable tags

## 2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window 06-0070841 EA20469-05 Rubber Strip 05-002898

Date: Wednesday, 4/5/2006 3:23:58 PM  
 User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 26544

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description:

- |   |            |                  |            |
|---|------------|------------------|------------|
| 1 | EA20469-06 | Aluminum Strip   | W.O. 40359 |
| 1 | EA20469-07 | Angle            | W.O. 40359 |
| 1 | EA20469-08 | Placard          | W.O. 40359 |
| 1 | EA20469-10 | Rear Rib Assy    | W.O. 40359 |
| 1 | EA20469-11 | Angle            | W.O. 40359 |
| 1 | EA20469-12 | Fwd Rib          | W.O. 40359 |
| 1 | EA20469-13 | Window           | W.O. 40359 |
| 1 | EA20469-14 | Window Retainer  | W.O. 40359 |
| 1 | EA20469-16 | Armrest Assy     | W.O. 40359 |
| 1 | EA20469-17 | Angle            | W.O. 40359 |
| 1 | EA20469-18 | Door Inner Skin  | W.O. 40359 |
| 1 | EA20469-21 | Door Cover Panel | W.O. 40359 |
| 2 | EA20469-23 | Link             | W.O. 40359 |
| 1 | EA20469-24 | Rod              | W.O. 40359 |
| 1 | EA20469-25 | Arm Assy         | W.O. 40359 |

Material Certification / Proof of Traceability / Certificate of Conformity required

## 3-EAGLE

Pick:

Qty Part Number Description Batch









- |     |                      |            |
|-----|----------------------|------------|
| 14  | AN3-3ABolt           | LT05010298 |
| 22  | AN3-4ABolt           | LT05010298 |
| 24  | AN3-7ABolt           | LT05010298 |
| 6   | AN960-6L Washer      | LT013051   |
| 90  | AN960-10L Washer     | LT05002632 |
| 34  | CR3242-4-2 Rivet     | LT05017444 |
| 135 | MS20426AD3-3 Rivet   | LT05002450 |
| 140 | MS20426AD4-3 Rivet   | 58802      |
| 25  | MS20470AD3-3 Rivet   | LT05002440 |
| 90  | MS20470AD4-3 Rivet   | LT05002440 |
| 24  | MS21042L3 Nut        | LT05002444 |
| 2   | MS21042L06 Nut       | LT05002444 |
| 13  | MS21068L3 Nut Plate  | LT05002444 |
| 8   | MS21069L08 Nut Plate | LT05002444 |
| 1   | MS21071L3 Nut Plate  | LT05002444 |
| 1   | MS21071L08 Nut Plate | LT05002444 |
| 9   | MS21075L3 Nut Plate  | LT05002444 |
| 2   | MS24677-12 Screw     | LT05002444 |
| 6   | MS27039-1-09 Screw   | LT05016746 |

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install  
 EA20469-15 or wiring harness at this time.



Date: Wednesday, 4/5/2006 3:23:58 PM  
User: Kim Johnston

### Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY	
Job Number: 28544		Part Number: D412711041	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
	5-Apply Dart P/N & B/N using fine point permanent marker		
4.0	QC4	INSPECT 100% KITS FOR COMPLETENESS	
			
Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS Send this W/O back to DartKit to be stocked at Eagle			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>          </u>			
6.0	DC	DOCUMENT CONTROL	
			
Comment: DOCUMENT CONTROL Inspection Level 21			
Job Completion			

*[Signature]*

*[Signature]*

N/A.








06.07.17

06.07.17

Dart Aerospace Ltd.

Wednesday, 4/5/2006 3:23:53 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: VERTICAL REFERENCE DOOR ASSEMBLY
Job Number	: 26544	Part Number	: D412711041
Estimate Number	: 10902	Drawing Number	: N/A
P.O. Number	:	Project Number	: N/A
This Issue	: 4/5/2006 S.O. No. :	Drawing Revision	: N/A
Prsht Rev.	: NC	Material	: N/A
First Issue	: 11 Type : PURCHASED PARTS	Due Date	: 4/28/2006
Previous Run	: 26543	Qty:	1 Um: Each
Written By	: <u>See comment below</u>		
Checked & Approved By	: <u>06.04.06</u>		
Comment	: Est Rev: A 04.08.18 New Issue KJ/DS		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description:	
1.0	PG	PURCHASING	
			
Comment: PURCHASING			
Issue P/O: <u>977</u> to Eagle Copters			
"Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041"			
Send a copy of this IPP <u>0.206/04/10</u> (1)			
2.0	D412711041	Vertical Ref. Door Assy	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)			
Vertical Ref. Door Assy			
3.0	OUTSIDE SERVICE	OUTSIDE SERVICES	
			
Comment: Sub-Contracting OUTSIDE SERVICES			
EAGLE			
Pick:Qty Part Number Description Batch			
1 204-030-853-119 LH Co-pilot Door <u>42456</u>			
Attach serviceable tags			
2- EAGLE			
Fabricate/Pick the following parts to go into the door in accordance with: D2046902 Sheet			
1 Rev. 3			
D2046902 Sheet 2 Rev. 2			
D2046902 Sheet 3 Rev. 0			
D2046901 Sheet 3 Rev. 1			
Qty Part Number Description Batch			
1 EB212-100L / EA20469-3 Window <u>06-007084</u>			
1 EA20469-05 Rubber Strip <u>05-002898</u>			



Date: Wednesday, 4/5/2006 3:23:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 26544

Part Number: D412711041

Job Number:



Seq. #: Machine Or Operation: Description :

1	EA20469-06	Aluminum Strip	W.O. 40359
1	EA20469-07	Angle	W.O. 40359
1	EA20469-08	Placard	W.O. 40359
1	EA20469-10	Rear Rib Assy	W.O. 40359
1	EA20469-11	Angle	W.O. 40359
1	EA20469-12	Fwd Rib	W.O. 40359
1	EA20469-13	Window	W.O. 40359
1	EA20469-14	Window Retainer	W.O. 40359
1	EA20469-16	Armrest Assy	W.O. 40359
1	EA20469-17	Angle	W.O. 40359
1	EA20469-18	Door Inner Skin	W.O. 40359
1	EA20469-21	Door Cover Panel	W.O. 40359
2	EA20469-23	Link	W.O. 40359
1	EA20469-24	Rod	W.O. 40359
1	EA20469-25	Arm Assy	W.O. 40359

Material Certification / Proof of Traceability / Certificate of Conformity required

## 3-EAGLE

Pick:

Qty Part Number Description Batch

14	AN3-3ABolt	KTOS010298
22	AN3-4ABolt	KTOS022456
24	AN3-7ABolt	KTOS022409
6	AN960-6L Washer	LTOL 3051
90	AN960-10L Washer	KTOS022632
34	CR3242-4-2 Rivet	KTOS017444
135	MS20426AD3-3 Rivet	KTOS022450
140	MS20426AD4-3 Rivet	53852
25	MS20470AD3-3 Rivet	KTOS022440
90	MS20470AD4-3 Rivet	KTOS022440
24	MS21042L3 Nut	KTOS022444
2	MS21042L06 Nut	KTOS022401
13	MS21069L3 Nut Plate	KTOS022628
8	MS21069L08 Nut Plate	KTOS022490
1	MS21071L3 Nut Plate	KTOS022463
1	MS21071L08 Nut Plate	KTOS022479
9	MS21075L3 Nut Plate	KTOS013490
2	MS24677-12 Screw	KTOS011931
6	MS27039-1-09 Screw	KTOS016246

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.



Date: Wednesday, 4/5/2006 3:23:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 26544

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Apply Dart P/N &amp; B/N using fine point permanent marker

4.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

N/A STOCKED AT EAGLE

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/05/18

Job Completion



u 06/05/18

**DART****Purchase Order**

Date Apr 10, 2006	Page 1
Purchase Order Number PO00000977	

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

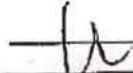
**Vendor Address:**

Eagle Copters Maintenance Ltd.  
823 McTavish Road  
Calgary, AB T2E 7G9  
Canada  
Phone (403) 250-7370  
Fax (403) 250-7110

**Ship To:**

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-EAG002	Apr 10, 2006	N30		

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
1.0000	D412-711-041	Vertical Ref. Door Assy Comments: ASSEMBLY OF D412-711-041 DOOR ASSEMBLY IN ACCORDANCE WITH DART IPP 0412-711-041 B26544		No	900.000000	Each	900.00
Comments:		Tax Summary:		Less:			
		GST		63.00		included tax	
		GSTME		0.00			
		GSTN/I		0.00			
		Entered By: C LAPROVEN		Subtotal		900.00	
		Approved By: 		Total tax		63.00	
				Total purchase order in			
				CAD Dollars		963.00	



Date: Wednesday, 4/5/2006 3:23:58 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	VERTICAL REFERENCE DOOR ASSEMBLY	
<b>Job Number</b> :	26544	<b>Part Number</b> :	D412711041	
<b>Estimate Number</b> :	10902	<b>Drawing Number</b> :	N/A	
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A	
<b>This Issue</b> :	4/5/2006	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Revision</b> :	N/A	
<b>First Issue</b> :	1/1	<b>Type</b> :	PURCHASED PARTS	
<b>Previous Run</b> :	26543	<b>Material</b> :	N/A	
<b>Written By</b> :		<b>Due Date</b> :	4/28/2006	<b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	<i>[Signature]</i> 06.04.06			
<b>Comment</b> :	Est Rev:A 04.08.18 New Issue KJ/DS			

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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## Comment: PURCHASING

Issue P/O: 977 to Eagle Copters

"Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041"

Send a copy of this IPP

*0206/04/10 (1)*

2.0	D412711041	Vertical Ref. Door Assy
-----	------------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Vertical Ref. Door Assy

3.0	OUTSIDE SERVICE	OUTSIDE SERVICES
-----	-----------------	------------------



## Comment: Sub-Contracting OUTSIDE SERVICES

## EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door \_\_\_\_\_

Attach serviceable tags

## 2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window \_\_\_\_\_

1 EA20469-05 Rubber Strip \_\_\_\_\_

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Wednesday, 4/5/2006 3:23:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFFERENCE DOOR ASSEMBLY

Job Number: 26544

Part Number: D412711041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1	EA20469-06	Aluminum Strip _____
1	EA20469-07	Angle _____
1	EA20469-08	Placard _____
1	EA20469-10	Rear Rib Assy _____
1	EA20469-11	Angle _____
1	EA20469-12	Fwd Rib _____
1	EA20469-13	Window _____
1	EA20469-14	Window Retainer _____
1	EA20469-16	Armrest Assy _____
1	EA20469-17	Angle _____
1	EA20469-18	Door Inner Skin _____
1	EA20469-21	Door Cover Panel _____
2	EA20469-23	Link _____
1	EA20469-24	Rod _____
1	EA20469-25	Arm Assy _____

Material Certification / Proof of Traceability / Certificate of Conformity required

### 3-EAGLE

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

14	AN3-3ABolt	_____	_____
22	AN3-4ABolt	_____	_____
24	AN3-7ABolt	_____	_____
6	AN960-6L Washer	_____	_____
90	AN960-10L Washer	_____	_____
34	CR3242-4-2 Rivet	_____	_____
135	MS20426AD3-3 Rivet	_____	_____
140	MS20426AD4-3 Rivet	_____	_____
25	MS20470AD3-3 Rivet	_____	_____
90	MS20470AD4-3 Rivet	_____	_____
24	MS21042L3 Nut	_____	_____
2	MS21042L06 Nut	_____	_____
13	MS21069L3 Nut Plate	_____	_____
8	MS21069L08 Nut Plate	_____	_____
1	MS21071L3 Nut Plate	_____	_____
1	MS21071L08 Nut Plate	_____	_____
9	MS21075L3 Nut Plate	_____	_____
2	MS24677-12 Screw	_____	_____
6	MS27039-1-09 Screw	_____	_____

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Wednesday, 4/5/2006 3:23:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFFERENCE DOOR ASSEMBLY

Job Number: 26544

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Apply Dart P/N & B/N using fine point permanent marker

4.0

QC4

1 QCS

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/05/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			








NOTE: Date & initial all entries



Dart Aerospace Ltd.

Date: Wednesday, 4/5/2006 3:23:56 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: VERTICAL REFERENCE DOOR ASSEMBLY
Job Number	: 26545	Part Number	: D412711041
Estimate Number	: 10902	Drawing Number	: N/A
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 4/5/2006 S.O. No. : N/A	Drawing Revision	: N/A
Print Rev.	: NC	Material	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Due Date	: 4/21/2006 Qty: 1 Unit Each
Previous Run	: 26542		
Written By	: <u>SEE COMMENT REPLY</u>		
Checked & Approved By	: <u>06.04.06</u>		
Comment	: Est Rev A 04.08.18 New Issue KJ/DS		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description:	
1.0	PG	PURCHASING	
			
Comment: PURCHASING			
Issue P/O: <u>978</u> to Eagle Copters			
"Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041"			
Send a copy of this IPP <u>C206/04/10</u> ①			
2.0	D412711041	Vertical Ref. Door Assy	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)			
Vertical Ref. Door Assy			
3.0	OUTSIDE SERVICE	OUTSIDE SERVICES	
			
Comment: Sub-Contracting OUTSIDE SERVICES			
EAGLE			
Pick: Qty Part Number Description Batch			
1 204-030-853-119 LH Co-pilot Door <u>42558</u>			
Attach serviceable tags			
2- EAGLE			
Fabricate/Pick the following parts to go into the door in accordance with: D2046902 Sheet			
1 Rev. 3			
D2046902 Sheet 2 Rev. 2			
D2046902 Sheet 3 Rev. 0			
D2046901 Sheet 3 Rev. 1			
Qty Part Number Description Batch			
1 EB212-100L / EA20469-3 Window <u>06-007084</u>			
1 EA20469-05 Rubber Strip <u>05-002898</u>			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 26543

Part Number: D412711041

Job Number:



1

Seq. #:	Machine Or Operation:	Description:
1	EA20469-06	Aluminum Strip <u>W.O. 40359</u>
1	EA20469-07	Angle <u>W.O. 40359</u>
1	EA20469-08	Placard <u>W.O. 40359</u>
1	EA20469-10	Rear Rib Assy <u>W.O. 40359</u>
1	EA20469-11	Angle <u>W.O. 40359</u>
1	EA20469-12	Fwd Rib <u>W.O. 40359</u>
1	EA20469-13	Window <u>W.O. 40359</u>
1	EA20469-14	Window Retainer <u>W.O. 40359</u>
1	EA20469-16	Armrest Assy <u>W.O. 40359</u>
1	EA20469-17	Angle <u>W.O. 40359</u>
1	EA20469-18	Door Inner Skin <u>W.O. 40359</u>
1	EA20469-21	Door Cover Panel <u>W.O. 40359</u>
2	EA20469-23	Link <u>W.O. 40359</u>
1	EA20469-24	Rod <u>W.O. 40359</u>
1	EA20469-25	Arm Assy <u>W.O. 40359</u>

Material Certification / Proof of Traceability / Certificate of Conformity required

## 3-EAGLE

Pick:

Qty Part Number Description Batch




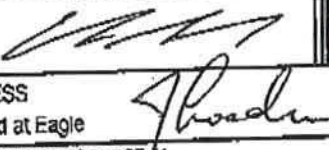




14 AN3-3ABolt KT05015678  
 22 AN3-4ABolt KT05026606  
 24 AN3-7ABolt KT05026607  
 6 AN960-8L Washer KT013051  
 90 AN960-10L Washer KT05026630  
 34 CR3242-4-2 Rivet KT05017444  
 135MS20426AD3-3 Rivet KT05026630  
 140MS20426AD4-3 Rivet 53852  
 25 MS20470AD3-3 Rivet KT05007440  
 90 MS20470AD4-3 Rivet KT05026640  
 24 MS21042L3 Nut KT05026644  
 2 MS21042L06 Nut KT05026644  
 13 MS21069L3 Nut Plate KT05026644  
 8 MS21069L08 Nut Plate KT05026644  
 1 MS21071L3 Nut Plate KT05026644  
 1 MS21071L08 Nut Plate KT05026644  
 9 MS21075L3 Nut Plate KT05017440  
 2 MS24677-12 Screw KT05017440  
 6 MS27039-1-09 Screw KT05016740

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 7 Rev. 5 Do not install  
 EA20469-15 or wiring harness at this time.



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# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY	
Job Number: 26543		Part Number: D412711041	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
	5-Apply Dart P/N & B/N using fine point permanent marker		
4.0	QC4	INSPECT 100% KITS FOR COMPLETENESS	
			
Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS Send this W/O back to DartKit to be stocked at Eagle			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____			
6.0	DC	DOCUMENT CONTROL	
			
Comment: DOCUMENT CONTROL Inspection Level 21			
Job Completion	